

Work Order ID 70945

Page 1

Monday, June 20, 2011 9:00:41 AM

Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Cap

Start Date: 6/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 2.00



Customer:

Reference: Rework

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2646

Rev C

150 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK:
2 X D2646 B62678
SCUFF LIGHTLY

M 11 06 28 (2)

165

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
DELFLEET BLUE B 115985
DELFLEET CLEAR B 117113

M 11 06 28 (2)

175

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

R 11-06-29 (2)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Install inserts as per Dwg D2646								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
200 	Identify as per dwg & Stock Location: <u>F R 4</u>	0.00							
Packaging	Memo	0.00							
Packaging									

h/a
Rework

2 *0* *11/11*

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/29 JF

H11-09-29
②

Picklist Print

Monday, June 20, 2011 9:00:38 AM

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Work Order ID: 70945



Parent Item: D2646



Parent Item Name: Aft Cap

Start Date: 6/20/2011

Required Date: 7/4/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: G 05.08.22 Hole size revised in Step 5 KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2646

Manufactured

No

Each

80.0000

2



Aft Cap

Location

Loc Qty

Loc Code

FP004

62

68280

62

FP006

18

62678

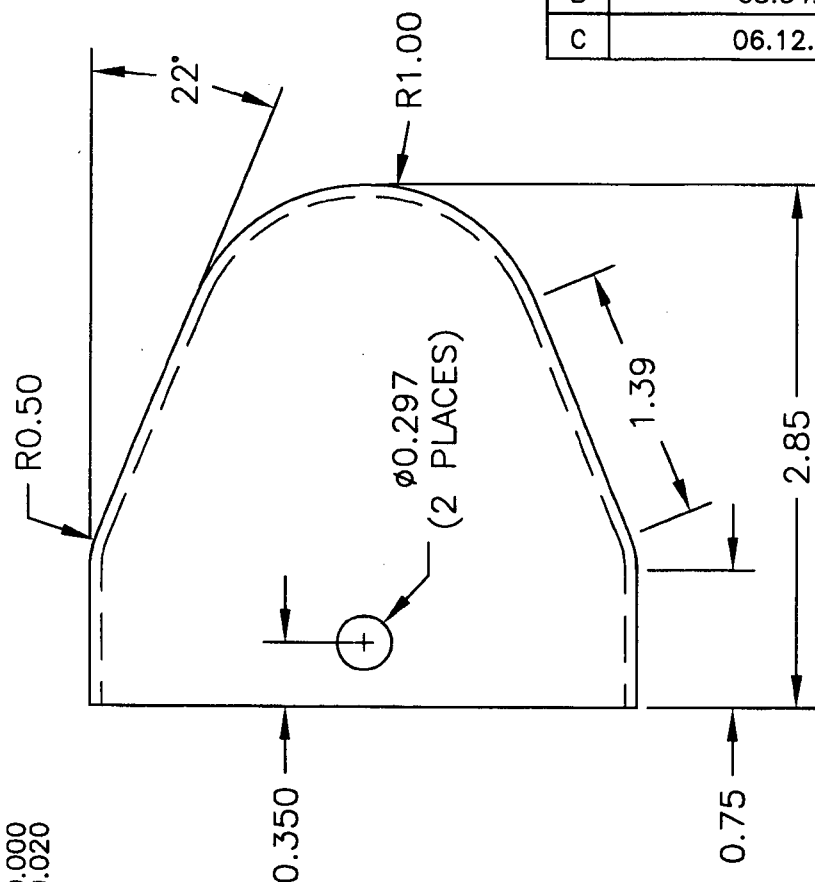
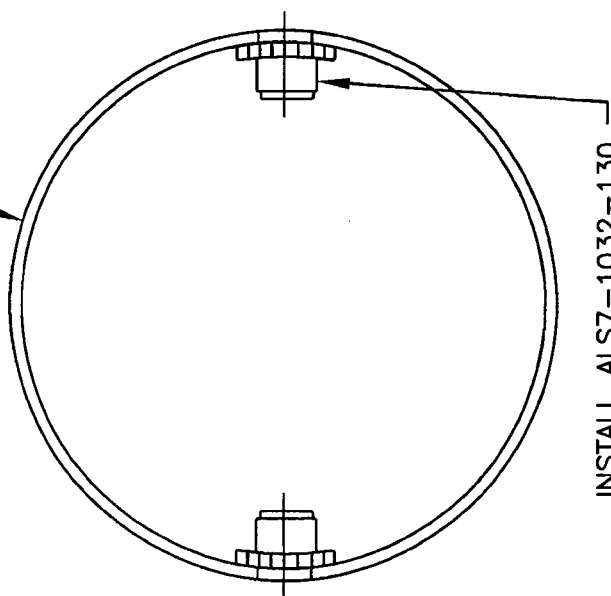
18

2

to 6.20.20

DART

DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2646	REV. C SHEET 1 OF 1
DATE 06.12.20		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		

 $\phi 2.980^{+0.000}_{-0.020}$ 

INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

RELEASED

07.02.12

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Wb 70445

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